

Work Order ID 52483

September 25, 2009 2:44:07 PM

Page 1

Item ID: PB67-43001-07 **GN**
 Revision ID: B1
 Item Name: Fwd Blade Fold Assembly Weldment

Accept

Setup Start

Stop

Start Date: 10/05/2009 Start Qty: 2.00
 Required Date: 10/16/2009 Req'd Qty: 2.00

Cust Item ID:
 Customer:

Reference:

Approvals: Process Plan: **MF** Date: **09-09-25** Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	Rev B1

100	Large Fab	0.00
Large Fab	Memo	0.00
Large Fab	1- assemble parts on jig DT8813 and weld as per dwg PB67-43001 *** ensure no burn thru after welding in tube -205 and -197 only where bushing -265 ***	

2X

Cpl 09 10 16

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
QC	Memo	0.00
Quality Control		

AD 09.10.19

120	QC5- Inspect part completeness to step on W/O	0.00
QC	Memo	0.00
Quality Control		

25 09/10/19

+2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 <i>M 18.144</i>	0.00	<i>=> 34</i>	<i>09/10/20</i>		<i>(X2)</i>	<i>0</i>		
Powdercoat	Memo	0.00							
Powder Coating	***mask inside of D3440-5, D3440-7 and D3440-15 prior to paint**** <input type="checkbox"/> START TIME: <i>7:15am</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>7:45am</i> <input type="checkbox"/> FINISH TIME: <i>320°</i>								
140 	QC3- Inspect Part Finish	0.00	<i>09-10-20</i>						
QC	Memo	0.00							
Quality Control									
150 	Identify as per dwg & Stock Location: <i>Ch</i>	0.00							
Packaging	Memo	0.00							
Packaging									

Ch 09 10 21

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/21 HJ

MF

69-10-21

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Work Order ID: 52483

Parent Item: PB67-43001-07RevB1

Parent Item Name: Fwd Blade Fold Assembly Weldment


Start Date: 10/05/2009

Required Date: 10/16/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3440-15RevA		Manufactured	No			100	Each	3.0000	2.0000			
												
Contoured Male Eye (Supersedes B67-43001-215)												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

41453

3

3

MF 09-10-03

D3440-5RevA		Manufactured	No			100	Each	4.0000	2.0000			
												
Contoured Detent Clip Base (Supersedes B67-43001-217)												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

41454

4

4

MF 09-10-03

D3440-7RevA		Manufactured	No			100	Each	4.0000	2.0000			
												
Detent Clip Base (Supersedes B67-43001-221)												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

41455

4

4

MF 09-10-03

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Parent Item: PB67-43001-07RevB1

Parent Item Name: Fwd Blade Fold Assembly Weldment


Start Date: 10/05/2009

Required Date: 10/16/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-197RevB1		Manufactured	No			100	Each	3.0000	2.0000			
												
Outer Tube												

stk

Warehouse
Location

Loc QtyLoc Code

Main Warehouse

ST

3

41483

3

PB67-43001-201RevB1

Square Tube

Manufactured No

100

Each

7.0000

2.0000

MF 09-10-03

stk

Warehouse
Location

Loc QtyLoc Code

Main Warehouse

ST

7

40592

3

44990

4

PB67-43001-203RevB1

Square Tube

Manufactured No

100

Each

5.0000

2.0000

MF 09-10-03

stk

Warehouse
Location

Loc QtyLoc Code

Main Warehouse

ST

5

41907

5

MF 09-10-03

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Required Date: 10/16/2009

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Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-205RevB1		Manufactured	No			100	Each	1.0000	2.0000			
Outer Tube												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45259

PB67-43001-207RevB1
Square Tube

Manufactured No

100

Each

0.0000

2.0000

PB67-43001-209RevB1
Square Tube

Manufactured No

100

Each

0.0000

2.0000

PB67-43001-211RevB1
Square Tube

Manufactured No

100

Each

23.0000

12.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

44989

PB67-43001-219RevB1
Angled Male Eye

Manufactured No

100

Each

0.0000

2.0000

B52603 → 1 Rpl 09.10.07

WF 09-10-03

B52604 → 2 Rpl 09.10.15

B52485 x 2 WF 09.10.03

CAY
WF 09-10-03

B52606 → 2 Rpl 09.10.15

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Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 10/05/2009

Required Date: 10/16/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-47RevB1		Manufactured	No			100	Each	0.0000	2.0000			
Base Assembly												

B52441 → 2
Cpl 09.10.15

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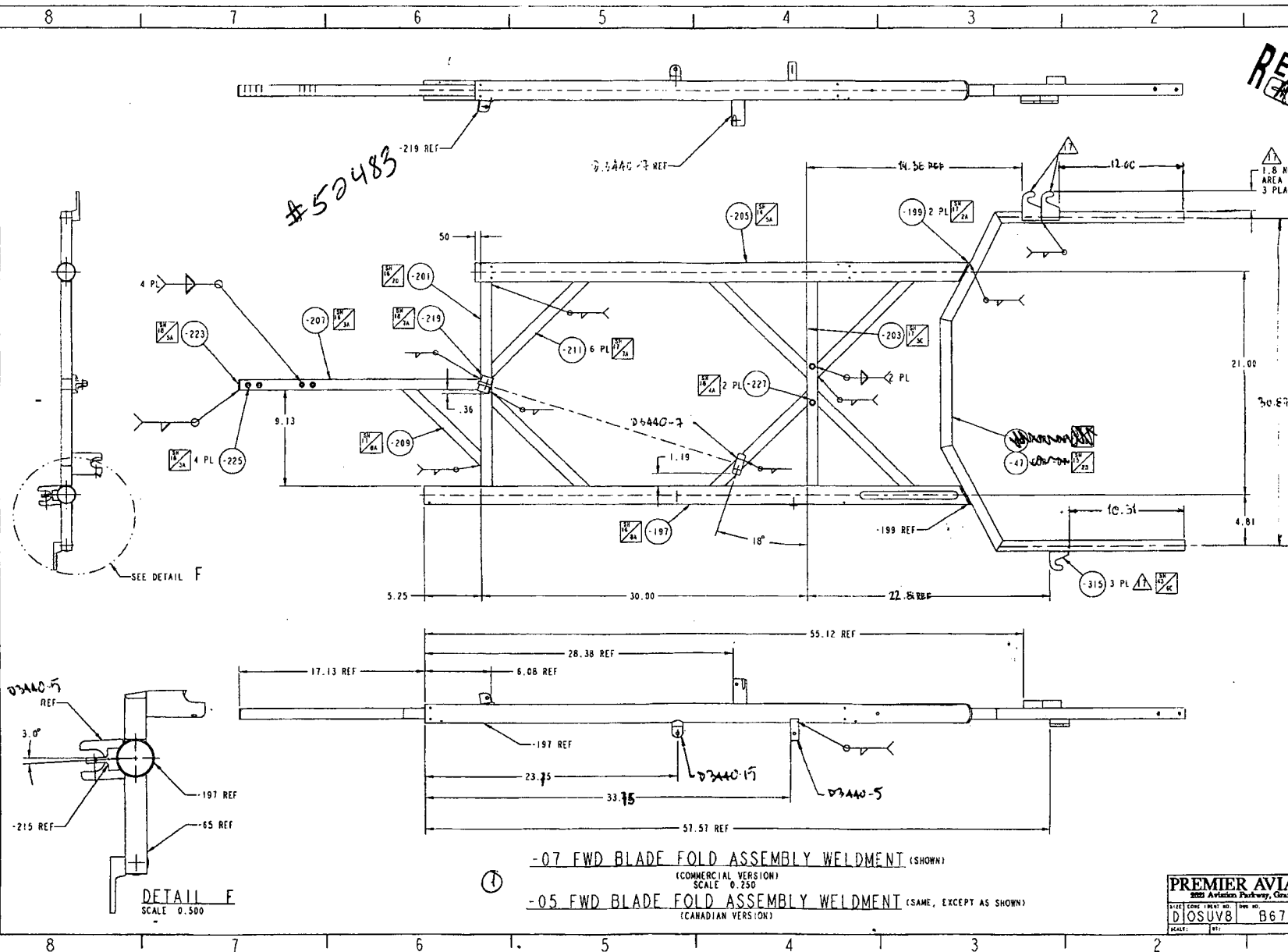
NOTE: Date & initial all entries

RELEASED
06.01.50

#52483

1.8 NO PAINT THIS AREA ALL AROUND -315 3 PLACES

30.87 REF



-07 FWD BLADE FOLD ASSEMBLY WELDMENT (SHOWN)
(COMMERCIAL VERSION)
SCALE 0.250

-05 FWD BLADE FOLD ASSEMBLY WELDMENT (SAME, EXCEPT AS SHOWN)
(CANADIAN VERSION)

PREMIER AVIATION, INC.
2002 Aviation Parkway, Grand Prairie, Texas 75050
D105UV8 B67-43001

ORIGINAL

W/O:		WORK ORDER CHANGES					
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